

To ship Jan 11/2016

Work Order ID 139168

139168

Page 1

November 16, 2015 9:56:37 AM

Item ID: D412-760-111

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Aft Cabin Wall & Pylon Protector

Stop *NS2*

Start Date: 11/16/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/11/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: SA Date: 20151116

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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IIN D412-760	G
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0.00

DAS
6
9-89

MCS 15-11-26

100

Document Control

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D412-760-111 CHG002

BAS
27
9-89

JAN 11 2016

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS
28
9-89

DEC 17 2015

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS
28
9-89

JAN 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐		AGAINST DEPARTMENT/PROCESS					
Date :		Step #:		QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 139168

139168

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November 16, 2015 9:56:37 AM

Item ID: D412-760-111

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Cabin Wall & Pylon Protector

Start Date: 11/16/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/11/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Codes

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

27
9-89

28
9-88

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-760-011
Location:FG040

Sold

JAN 11 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCS JAN 11 2016

Sgt 20160111

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

November 16, 2015 9:56:44 AM

Page 1

Work Order ID: 139168

139168

Parent Item: D412-760-111

D412-760-111

Parent Item Name: Aft Cabin Wall & Pylon Protector

Start Date: 11/16/2015

Required Date: 1/11/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.04.19 per ecn10-646 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3933-1 *D3933-1* Aft Wall Protector		Manufactured	No			110	Each	0.0000	1	1		DAS 28 9-89	
D3933-2 *D3933-2* Aft Wall Protector, RH		Manufactured	No			110	Each	0.0000	1	1		DAS 6 9-89	
D3935-1 *D3935-1* Pylon Wall Protector, LH		Manufactured	No			110	Each	1.0000	1	1		DAS 6 9-89	DAS 28 9-89
DAS 27 9-89 Location ST500 136341 Loc Qty 1 Loc Code													
D3935-2 *D3935-2* Pylon Wall		Manufactured	No			110	Each	1.0000	1	1		DAS 6 9-89	DAS 28 9-89
DAS 27 9-89 Location ST500 136342 Loc Qty 1 Loc Code													
D3942-1 *D3942-1* Angle		Manufactured	No			110	Each	42.0000	14	14		DAS 6 9-89	DAS 28 9-89
DAS 27 9-89 Location ST060 136343 Loc Qty 42 Loc Code													

JAN 08 2016

Picklist Print

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Work Order ID: 139168

Parent Item: D412-760-111

Parent Item Name: Aft Cabin Wall & Pylon Protector

139168

D412-760-111

Start Date: 11/16/2015

Required Date: 1/11/2016

Start Qty: 1.00

Required Qty: 1.00

D3942-3

Manufactured No

110

Each

38.0000

10

10

D3942-3

Clip

BAS
27
9-89

Location

Loc Qty

Loc Code

ST060

38

136345

38

DAS
28
9-89

MS27039-4-10

Purchased

No

110

Each

76.0000

4

4

MS27039-4-10

Screw

BAS
27
9-89

Location

Loc Qty

Loc Code

ST283

76

m131885

76

DAS
28
9-89

MS27039-4-14

Purchased

No

110

Each

58.0000

6

6

MS27039-4-14

SCREW

BAS
27
9-89

Location

Loc Qty

Loc Code

CA

13

m129682

13

ST283

45

m131197

45

DAS
28
9-89

MS27039-5-08

Purchased

No

110

Each

20.0000

6

6

MS27039-5-08

Screw

BAS
27
9-89

Location

Loc Qty

Loc Code

ST282

20

m131896

20

DAS
28
9-89

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Shop Packet Print

Page 2

DEC 17 2015

Picklist Print

November 16, 2015 9:56:45 AM

Page 3

Work Order ID: 139168

139168

Parent Item: D412-760-111

D412-760-111

Parent Item Name: Aft Cabin Wall & Pylon Protector

Start Date: 11/16/2015

Required Date: 1/11/2016

Start Qty: 1.00

Required Qty: 1.00

MS27039-5-12

Purchased

No

110

Each

21.0000

8

8

DAS

0

9-89

DEC 17 2015

MS27039-5-12

Screw

**

Location

Loc Qty

Loc Code

DAS

28

9-89

ST282

21

m131886

21

DAS
27
9-89

REFERENCE ONLY

DART AEROSPACE LTD.

DAS
27
9-89

IIN-D412-760
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Qty -111	Qty -113	Part Number	Description
X		D412-760-111	AFT CABIN WALL AND PYLON PROTECTOR KIT
	X	D412-760-113	AFT CABIN WALL AND PYLON PROTECTOR KIT
1	1	D3933-1	LH AFT CABIN WALL PROTECTOR
1	1	D3933-2	RH AFT CABIN WALL PROTECTOR
1		D3935-1	LH PYLON PROTECTOR
1		D3935-2	RH PYLON PROTECTOR
	1	D3935-3	LH PYLON PROTECTOR
	1	D3935-4	RH PYLON PROTECTOR
14	14	D3942-1	ANGLE
10	10	D3942-3	CLIP
4	4	MS27039-4-10	SCREW
6	6	MS27039-4-14	SCREW
6	6	MS27039-5-08	SCREW
8	8	MS27039-5-12	SCREW

Qty -211	Qty -213	Qty -215	Qty -217	Part Number	Description
X				D412-760-211	BAGGAGE COMPARTMENT PROTECTOR KIT
	X			D412-760-213	BAGGAGE COMPARTMENT CEILING PROTECTOR KIT
		X		D412-760-215	CARGO FLOOR PROTECTOR KIT
			X	D412-760-217	LIGHTWEIGHT BAGGAGE COMPARTMENT PROTECTOR KIT
36	7	8		D3628-1	CUPPED WASHER
			43	D3628-5	CUPPED WASHER
1				D3876-1	RH FORWARD WALL PROTECTOR
1				D3876-3	FORWARD WALL PROTECTOR
1				D3876-5	LH WALL PROTECTOR
1				D3876-7	AFT WALL PROTECTOR
1				D3876-9	RH AFT WALL PROTECTOR
1		1		D3876-11	FLOOR PROTECTOR
1				D3876-13	DOOR PROTECTOR
1		1		D3952-1	PLACARD
			1	D3952-3	PLACARD
	1			D4438-1	CEILING PROTECTOR
			1	D4640-1	RH FWD WALL PROTECTOR
			1	D4640-3	FORWARD WALL PROTECTOR
			1	D4640-5	LH WALL PROTECTOR
			1	D4640-7	AFT WALL PROTECTOR
			1	D4640-9	RH AFT WALL PROTECTOR
			1	D4640-11	FLOOR PROTECTOR
			1	D4640-13	DOOR PROTECTOR
			1	D4640-15	CEILING PROTECTOR
36		8	36	80-004-2-6	INSERT
	7		7	80-004-2-8	INSERT
36		8	36	MS27039-1-04	SCREW
	7		7	MS27039-1-05	SCREW
	3		3	MS27039-1-10	SCREW
	6		6	NAS1149F0363P	WASHER (AN960-10)

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Revision: G
Date: 13.01.03